

Work Order ID 56867

March 11, 2010 10:48:44 AM



Page 1

Item ID: D130-700-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-3-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3167	Rev A1	0.00	S.10/03/31	
100	DOCUMENT CONTROL	0.00		
	Memo	0.00		
DC	Photocopy bluefile and create labels per PPP D130-700-011CHG001			
Document Control				

120	FLOW WATER JET	0.00		
	Memo	0.00		
Waterjet	Cut Blank as per File D3167-1_BLANK			
FLOW CNC Waterjet				

130	HAAS CNC VERTICAL MACHINING #1	0.00	8/10/03/23	
	Memo	0.00	2nd 10/03/24	
HAAS 1	Note: (2) Bearpaw for (1) Kit <input type="checkbox"/> Inspect material for defects or damage prior to machining <input type="checkbox"/> Machine as per Folio FA285 and Dwg D3167 <input type="checkbox"/> Deburr			
HAAS CNC vertical machine #1				

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

8.9 10/03/23 /mf 00/03/24

8 0

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

y.a 10/03/29

8 0

160



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

PICK KIT 4

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Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10231

+4

180



Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D130-700-011 Location: _____

ARVA

10/3/2010

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/4/2010

AR 10-4-5
4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 56867



Parent Item: D130-700-011



Parent Item Name: Bearpaw

Start Date: 11/03/2010

Required Date: 18/03/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	418.2888	28.7158			LB 10-3-15

UHMW 1" Black

Warehouse

Location

Main Warehouse

MAT	386.5411
112186	122.0164
113166	21.6264
113903	242.8983

Main Warehouse

ST	31.7477
111354	31.7477

AN4-12A

4P



Bolt

Purchased

No

Loc Qty

Loc Code

(8)

113903

Warehouse

Location

Main Warehouse

ST357	327
105143	1
111605	13
111925	5
112314	300
6071	8

Loc Qty

Loc Code

14/3/29(4)

1112314

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AN4-15A	\$10	Purchased	No			170	Each	263.0000	32.0000		11/14/2010	C

Warehouse

Location

Main Warehouse

ST358	263	
113121	6	
113538	1	
113840	120	
114108	136	

AN960JD416 124 Purchased No 170 Each 0.0000 48.0000

11/14/2010 C

AN960JD416 124 Purchased No 170 Each 0.0000 48.0000



11/14/2010 C

D2182B 44 @ 6.001 Manufactured No 170 f 152.4470 8.0000



11/14/2010 C

Warehouse

Location

Main Warehouse

ST	29.886	
28042	7.33	
30872	0.33	
45405	22.226	

Main Warehouse

ST410	122.5610211	
52649	122.561021	

52649

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Parent Item Name: Bearpaw

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2274		Manufactured	No			170	Each	240.0000	48.0000			
-------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



Radius Block

B47796 84 C

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	190
55602	190

Main Warehouse

ST010	50
52644	29
54850	10
55443	11

D2519	Manufactured	No		170	Each	10.0000	16.0000
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Clamp

55602 96X

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	10
43842	10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 56867



Parent Item: D130-700-011



Parent Item Name: Bearpaw

Start Date: 11/03/2010

Required Date: 18/03/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 4.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2529 12X
Washer

Manufactured No 170 Each 290.0000 48.0000 ✓



B45338 8X

C 143/29

D3171-1 4X
Angle

Manufactured No 170 Each 6.0000 16.0000



S6184 40X

B 57199 C 143/31

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Parent Item: D130-700-011



Parent Item Name: Bearpaw

Start Date: 11/03/2010

Required Date: 18/03/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4	120	Purchased		No		170	Each	2,358.000	48.0000		11/03/2010	

6 Nut

Warehouse Location	Loc Qty	Loc Code		
			Main Warehouse	
ST300	2358			
102552	6			
104248	6			
110507	184			
111827	186			
113422	976			
114108	1000			

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S6367
Description: Bearpaw	Part Number:	D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.S	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/03/22	Date:	10/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF ✓	+

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

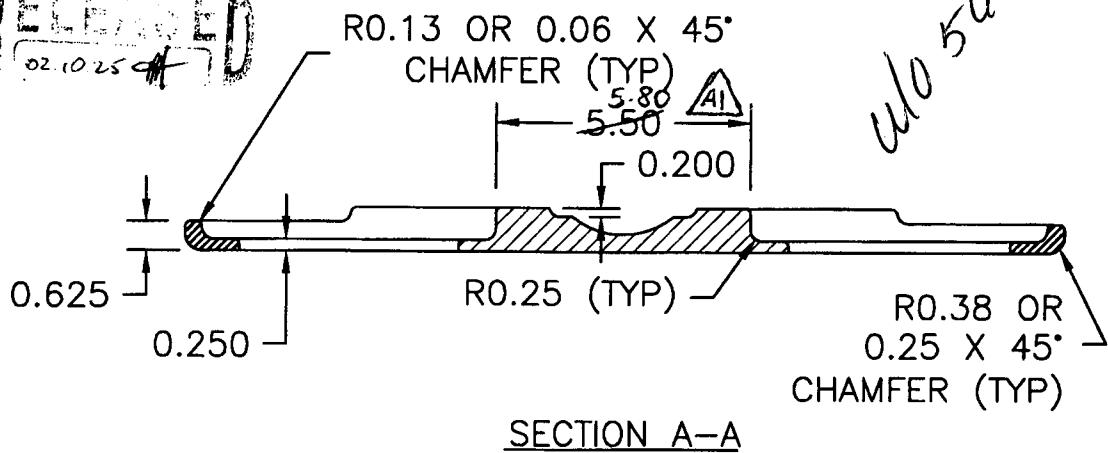
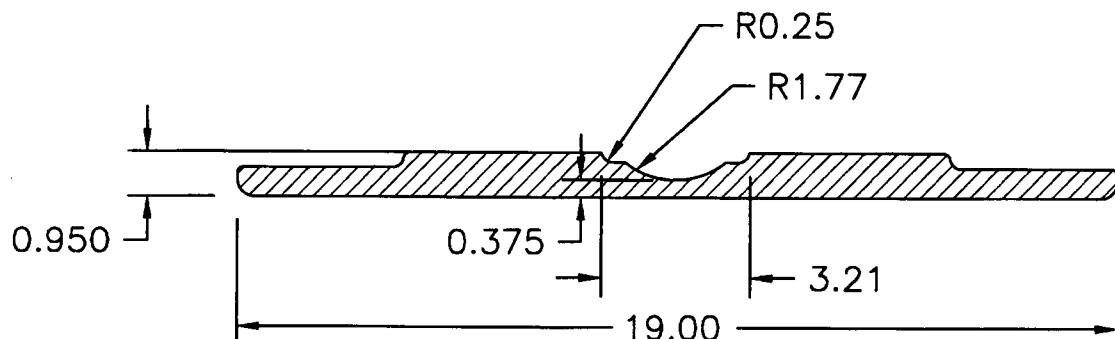
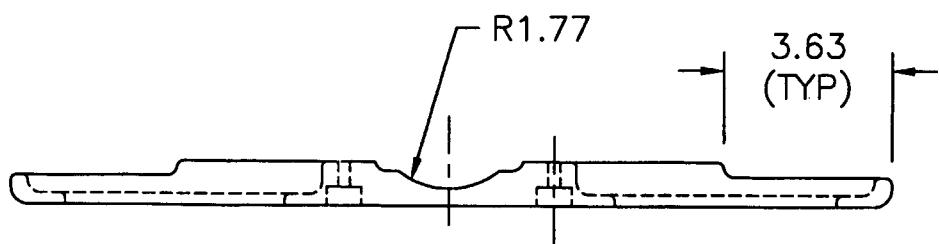
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3167
DATE	02.10.08	TITLE BEARPAW

REV. A
SHEET 2 OF 2
SCALE
1:4~~RELEASED~~
02.10.08SECTION A-ASECTION B-BSECTION C-C

W/O:		WORK ORDER CHANGES					
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32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-700-011 Bearpaw Installation	12.5 lb 5.67 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	159.8 in 4.05 m	1998 in-lb 23.0 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D130-700-011	BEARPAW INSTALLATION
4	D2182B060	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
4	D2519	Clamp
2	D3167-1	Bearpaw
4	D3171-1	Angle
4	AN4-12A	Bolt
8	AN4-15A	Bolt
12	AN960JD416	Washer
12	MS21042L4	Nut (or MS21042-4)

TC Accepted
DEC 18 2002

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32-00-00

Revision: 0

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